

Date: Tuesday, 01/04/2008 3:45:39 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKIDTUBE ASSEMBLY
Job Number :	38278		
Estimate Number :	10022		
P.O. Number :		Part Number :	D205634011
This Issue :	01/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	/ /	Project Number :	N/A
Previous Run :	38277	Drawing Revision :	N/A
	Type :	Material :	
	LANDING GEAR	Due Date :	18/04/2008
Written By :		Qty:	1
Checked & Approved By :	<u>JD 08.4.01</u>	Um:	Each
Comment :	Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011

CHG005

5 08/04/22 08/4/11 JLD

2.0	38278A	SKID TUBE ASSEMBLY
-----	--------	--------------------



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 08278A

SP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------



100

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	31280

8/4/22

SP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/04/22 (FL)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:45:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 38278

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: 2

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-22

B38278A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 38278A
 Estimate Number : 10023
 P.O. Number :
 This Issue : 01/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run : 38277A
 Part Number : D205634041
 Drawing Number : D2580 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 18/04/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JD 08-4-01
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 Est Rev. O 06.02.28 Added paperwork EC
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL NA JD 08-4-01
 Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

2.0	D25001190	Ext'n -I' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	<u>B34729</u>

JD 8-4-8

3.0	D2596	205 Web
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	<u>B37753</u>

JD 8-4-8

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburrr ends

3-Acid etch and Alodine tube per QSI 005 4.1

JD 8-4-8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38278A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08/04/08

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	M 107397	
Sikaflex expire date: 8-7-31			
Start Time: 2:15		Date: 8-4-8	
Fin Time: 3:30		Date: 8-4-9	

-AWM
8-4-8

JB 8-4-8

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/JD 8-4-9

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

JB 8-4-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38278A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08-04-11

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2576-3

Step

BE 08-04-12

BE 08-04-12

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

20

D2579

Spacers

BE 08-04-12

BE 08-04-12

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M107263

BE 08/04/12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M107263

BE 08/04/12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending A.m 08.04.15 ①

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur 08.04.15 ①

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes a.m 08.04.15 ①

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur a.m 08.04.15 ①

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur a.m 08.04.15 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: N/A Fault Category: Prod / Skid tube NCR: (Yes) No DQA: (D) Date: 08/04/23
 QA: N/C Closed: (L) Date: 08/04/23

NCR: <u>38278A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-04-16</u>	<u>12.0</u>	Just past the aft saddle location along the bottom side of the ridge, there is a gouge due to filing off the weld. R.C. Employee made too many long passes with the file in the same spot. 0.006" deep. <u>0.006"</u>	<u>Q21042</u>	File with 1/8" double end file grind flush.	<u>(Signature)</u> No need. <u>8-4-16</u>	<u>(Signature)</u> <u>08-04-16</u>	<u>Q21042</u>	<u>08-04-16</u>

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
User: Julie Lecocq

Process Sheet

30 min

17/04/2008

S.042

#1 323.1 F

#2 D205634041

#3 B38278A

#4

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38278A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

14.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

16.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0	D2855	Cap
------	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Cap
Batch: 1337570

19.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: M100188

20.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Washer
Batch: M1104885

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38278A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M105855

JS

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M1107376

JS

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M1107376

JS

24.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

JS

25.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B338298

JS

26.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: (1x)=7B38048(1x)=7B38410

JS

27.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B338047

JS

08-04-18 (21)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38278A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1337811

92

29.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1337812

91

30.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1338297

91

31.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: 1329908

91

32.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: 1337926

91

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

CA/R

Sikaflex-291

M107397

Sikaflex expire date: 08/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

91 08-04-18

91

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:46:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38278A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M107397 > JJ 08-04-18 (X)
L Sikaflex expire date: 08-10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M106894

FL 08/04/21 (1)

34.0

QC5

INSPECT WORK TO CURRENT STEP



5 08/04/21 (1)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

~~PP~~ 38278 / 8/22 (1)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/23 (1)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 382787

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RELEASED
07-06-28

Diagram illustrating the underside of the D2576-3 step, showing grinding locations:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular base plate with a central hole and a rectangular cutout. The drawing includes dimensions and labels for components and materials.

Dimensions:

- Overall diameter: $\phi 0.208$
- Central hole diameter: $\phi 0.40$
- Rectangular cutout dimensions: 0.10×0.10

Labels and Components:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- AN3-5A BOLT (1)
- AN960UDTOL WASHER (1)
- (2 PLACES)
- D2855 CAP
- SEAL WITH SIKAFLEX-241/-291

D2579 SPACER

WEB (REF)

130 (REF)
0 PLACES

AFTER PERFORM
1. CHA
2. INS
3. WEL
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2596 WEB

38.0

1.750

1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

91.500

190.0
(D2500-1)

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 | 1.5 | 1.5 | D | P | P | P | P | P | P | P | 1.5 | 1.5 | 1.5

8

REFER TO DETAIL C

D3566-1 | D3566-5 | D3566-1 | D3566-13

D3564-11 | D3564-5 | D3564-9 | D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	JJ	DRAWN BY	
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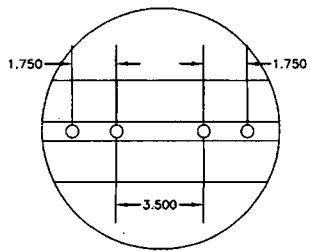
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DATE			
07.02.27			

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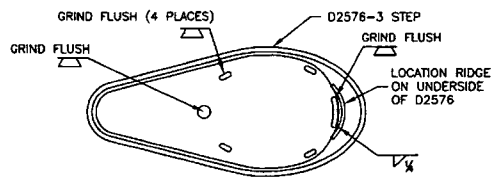
DRAWING NO.	REV. 0
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

DETAIL E
SCALE 5:24

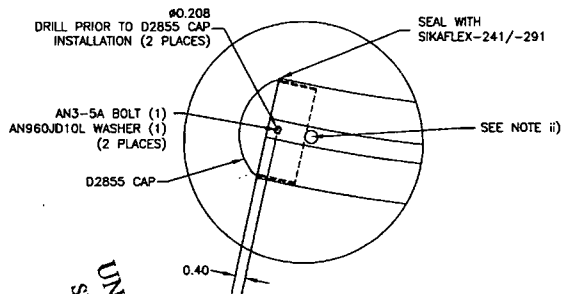


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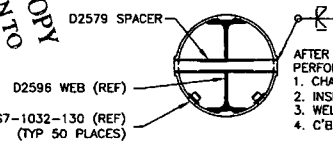
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24

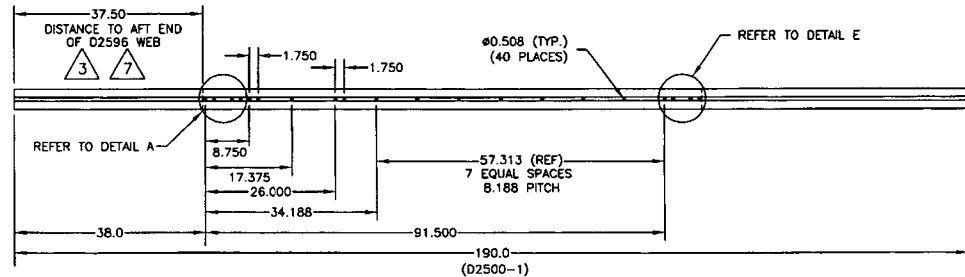


SECTION H-H
SCALE 5:24

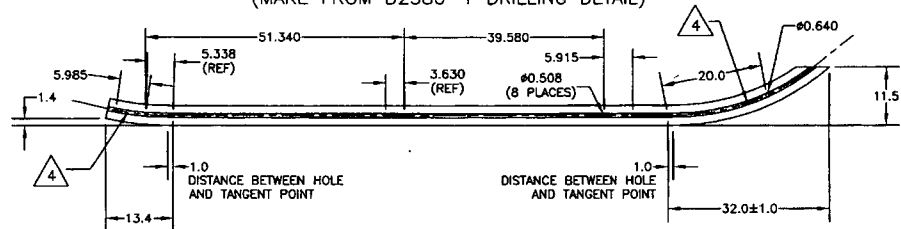


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR $\phi 0.508$ HOLES ONLY:
1. CHAMFER HOLE $0.050 \times 45^\circ$
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO $\phi 0.437 \times 1.00$ DEEP

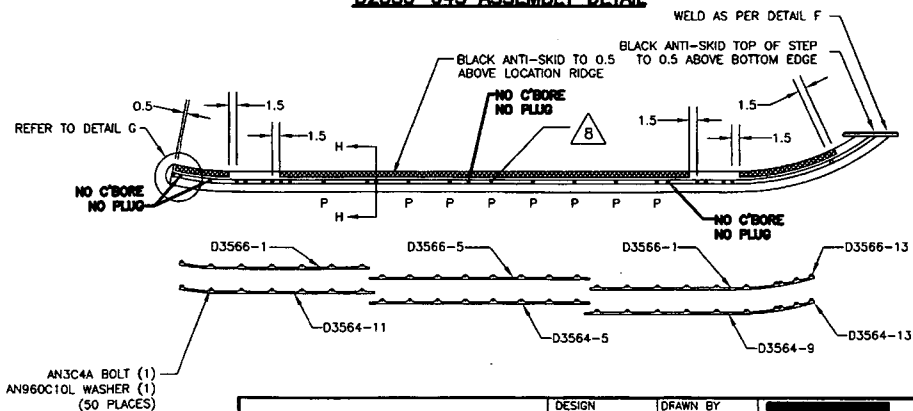
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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CHECKED <i>RH</i>	APPROVED <i>RH</i>		MARKHAM, ONTARIO, CANADA
DATE	DRAWING NO.	TITLE	REV. 0
07.02.27	D2580	205 SKIDTUBE ASSEMBLY	SHEET 3 OF 3
			SCALE 1:24